

Work Order ID 128787

Tuesday, January 27, 2015 7:47:56 AM

128787

Page 1

Item ID: D3304-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tube Assembly
Start Date: 1/26/15 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 1/26/15 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: MLS Date: 15-01-28 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3304	Rev B								
100	BAND SAW	0.00				2	0		J.C.L. 15/02/02
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	1- Cut blank: 22.00" as per Dwg D3304								
110	CONVENTIONAL LATHE	0.00				2	0		J.C.L. 15/02/02
110									
Lathe Conv	Memo	0.00							
Conventional Lathe	1- Cut blank: 22.00" as per Dwg D33042- Turn as per Dwg D33043- Deburr								
120	QC2- Inspect parts off machine FAI/FAIB	0.00				2	0		J.C.L. 15/02/02
120									
QC	Memo	0.00							
Quality Control									

DAS
44 15/02/02
9-89

DAS
44 15/02/02
9-89

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WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 4

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Item Name: Tube Assembly
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Required Date: 1/26/15 Req'd Qty: 2.00 ***2*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3 <i>M 128564</i> Memo START TIME: <i>2:25</i> OVEN TEMPERATURE: <i>300</i> FINISH TIME: <i>2:55</i>	0.00 0.00				<i>2</i>	<i>0</i>	<i>15-3-31</i>	<i>253</i>
200 *200* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00			DAS 30 9-89	<i>2</i>			<i>15/02/31</i>
210 *210* Small Fab Small Fab	Small Fab Memo Assemble lanyard and pip pin as per Dwg D3304Identify as D3304-043	0.00 0.00				<i>2</i>	<i>FF</i>	<i>APR 01 2015</i>	

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Picklist Print

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Page 1

Work Order ID: 128787

128787

Parent Item: D3304-043

D3304-043

Parent Item Name: Tube Assembly

Start Date: 1/26/15

Required Date: 1/26/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: D 04.11.26 Revised Step 7 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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BLBS-0016		Purchased		No		210	Each	16.0000	1	2			
RI RS-0016												APR 01 2015	
PIP PIN													

Location	Loc Qty	Loc Code
ST551	16	
123507	5	
m129540	7	
m129942	1	
m129993	3	

CBL-1240		Purchased		No		100	f	260.0000	1.0416	2.0832			
CBI -1240												APR 01 2015	
Cable													

Location	Loc Qty	Loc Code
GA	260	
m130006	260	

CBL-460		Purchased		No		210	Each	124.0000	2	4			
CBI -460												APR 01 2015	
Loop Sleeve													

Location	Loc Qty	Loc Code
GA	124	
* m129753	124	

D3304-7		Manufactured		No		210	Each	10.0000	1	2			
D3304-7													
Bracket													

Location	Loc Qty	Loc Code
WA002	10	
120484	3	
126291	7	

x2 15-03-23 MAL

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Parent Item: D3304-043

D3304-043

Parent Item Name: Tube Assembly

Start Date: 1/26/15

Required Date: 1/26/15

Start Qty: 2.00

Required Qty: 2.00

M304TR0.875W.065

Purchased

No

160

f

19.0100

1.8542

3.903579

M304TR0 875W 065

J.C. - L

304 round tube .875 x .065w

Location

Loc Qty

Loc Code

MAT038

19.01

m128118

13.2

m129466

5.81

3.6881 15/02/02

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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

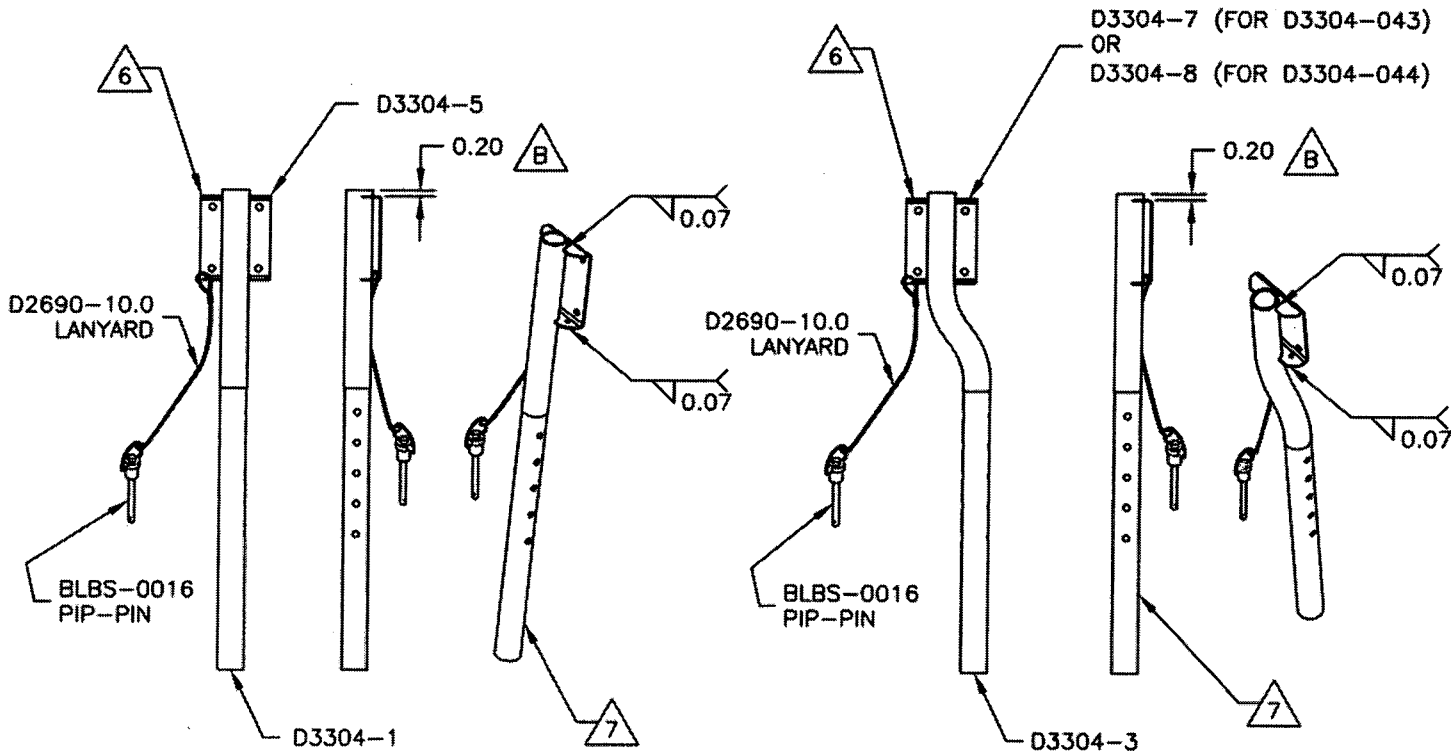
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DESIGN		DRAWN BY		DART AEROSPACE LTD	
RF		RF		HAMKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. B
DATE	05.07.15			D3304	SHEET 1 OF 4
				TITLE	SCALE
				TUBE ASSEMBLY	1:6
A	04.08.18	NEW ISSUE			
B	05.07.15	UPDATE DIMENSIONS; ADD D3304-7/-8			



D3304-041 TUBE ASSEMBLY

**D3304-044 TUBE ASSEMBLY (SHOWN)
D3304-043 OPPOSITE**

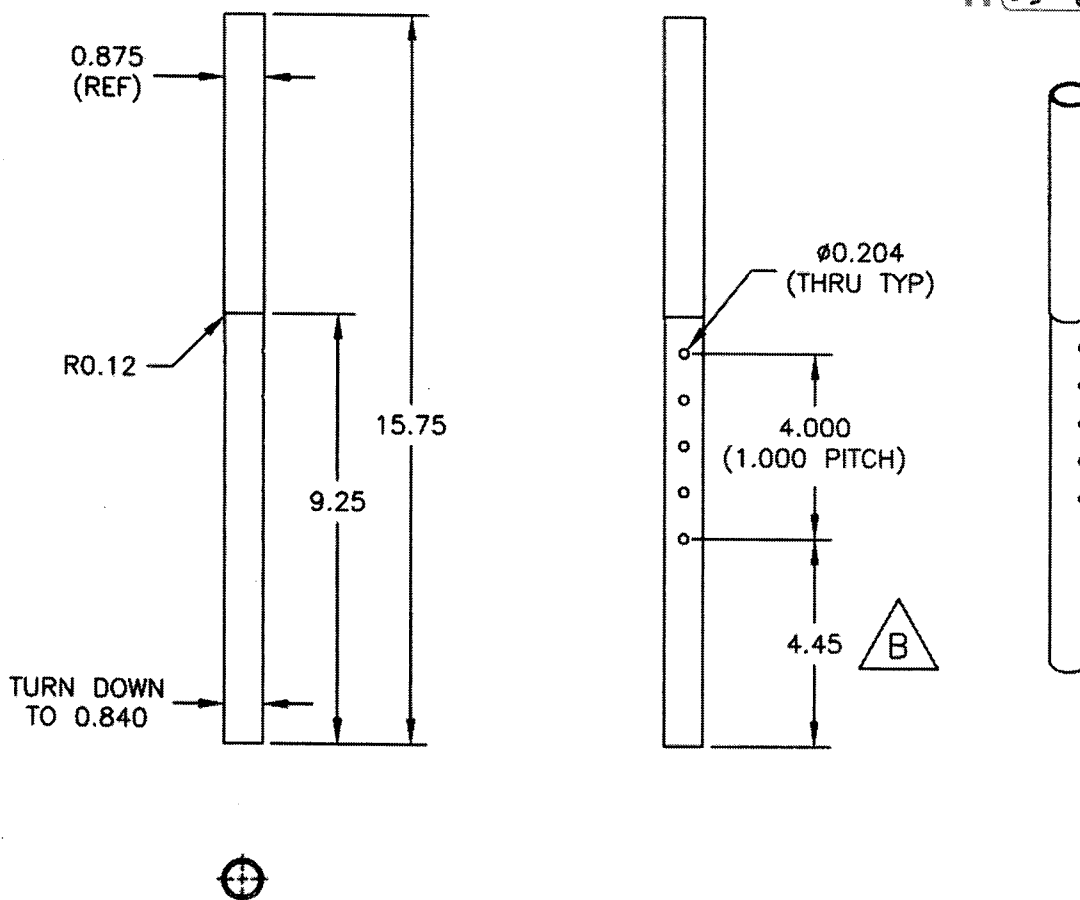
D3304-041/-043/-044 NOTES:

- 1) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) IDENTIFY AS INDICATED USING FINE POINT PERMANENT INK MARKER "TCCA-PDA, DART AEROSPACE LTD, P/N D3304-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"
- 7) IF BEING ASSEMBLED WITH D3303-041, ADD THE FOLLOWING USING A FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD, P/N D412-724-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

RELEASED
25-08-11

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3304	REV. 8 SHEET 2 OF 4
DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:4

RELEASED
05.08.11 *[Signature]***D3304-1 TUBE****D3304-1 NOTES:**

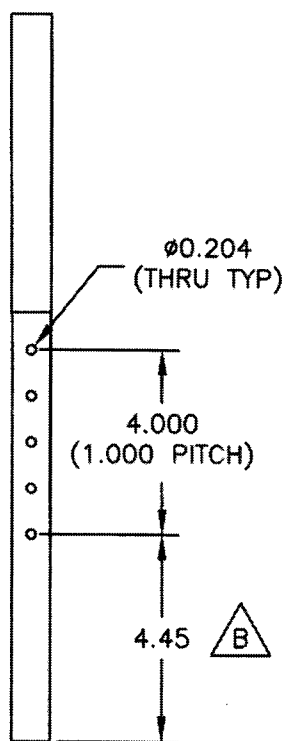
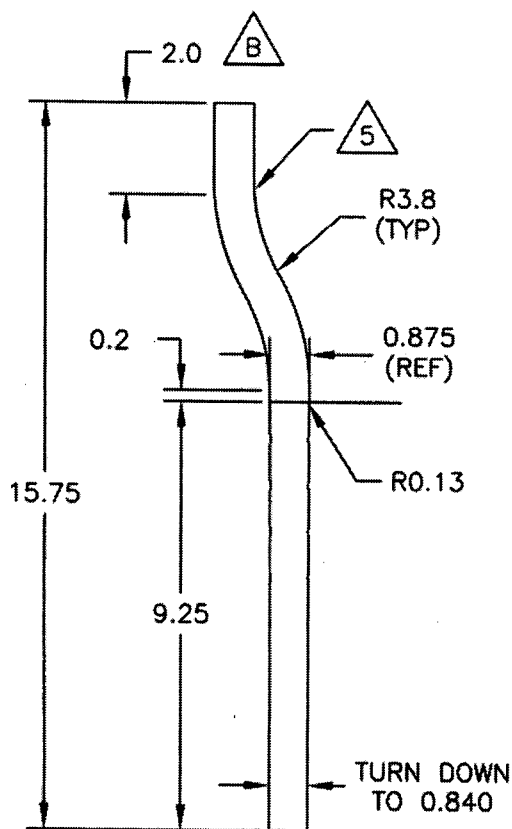
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.875 x 0.065 WALL (REF. DART SPEC M304TRO.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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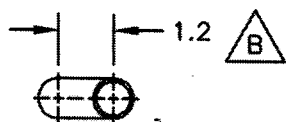
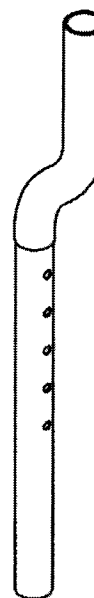
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3304	REV. B SHEET 3 OF 4
DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:4



RELEASED
05-08-11



D3304-3 TUBE

D3304-3 NOTES:

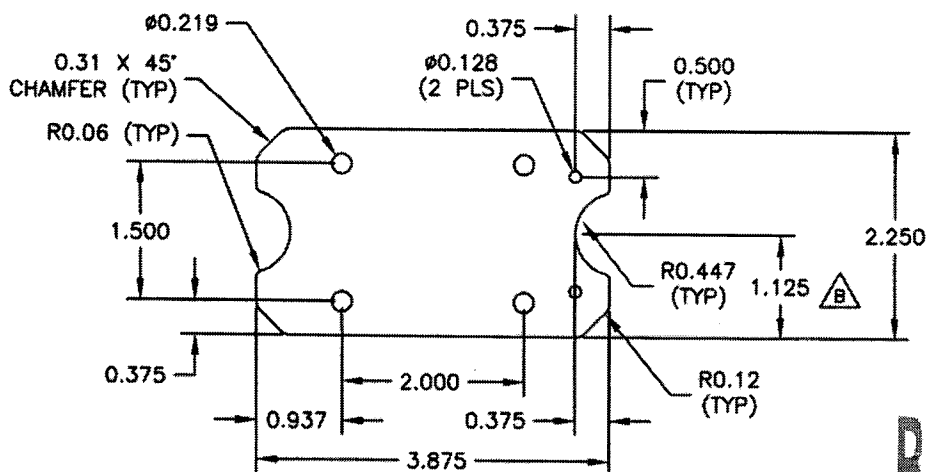
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.875 \times 0.065$ WALL
(REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) BEND LINES 9.625, 13.375 DIMENSIONS

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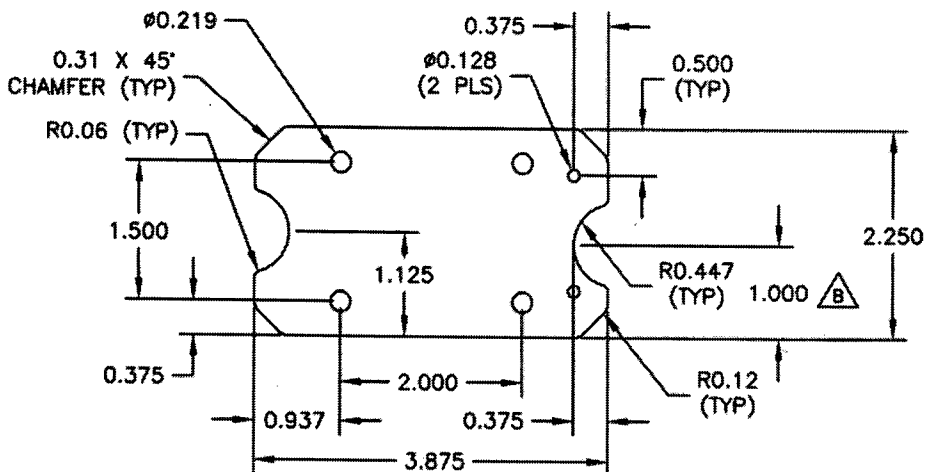


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3304	REV. B SHEET 4 OF 4
DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:2

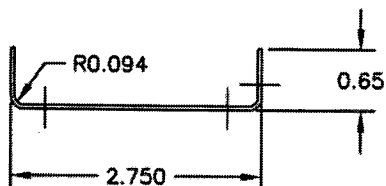


D3304-5 FLAT PATTERN

RELEASED
05.08.11



D3304-7/-8 FLAT PATTERN



**D3304-5/-7 BRACKET
D3304-8 OPPOSITE**

NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.040 THICK SHEET (REF. DART SPEC M304S20GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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